

Work Order ID 162690

Thursday, June 08, 2017 1:22:26 PM

162690

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Item ID: D3882-1-130

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Extrusion "I" Beam

Stop *NS2*

Start Date: 6/9/2017 Start Qty: 80.00

Required Date: 7/6/2017 Req'd Qty: 80.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3882	Rev A

100 0.00

100

Purchasing

Purchasing

Memo

PURCHASING

Issue P/O: 36700

- a) Extrude as per Dwg D3882
- b) Material: 6061-T6 (QQ-A-200/8) OR ASTM B221
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 130" long
- g) Bon L Canada Inc. tool #DAA-6
- H Pull test to ASTM standard B221 required.
- J) Material certification is required

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

1 CRATE 22" x 17" x 132"
Both 22" x 35" x 132"
(If stacked)

63 JUN 14 2017

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Item ID: D3882-1-130 Accept ***N900040100*** Setup Start ***NS1***
Revision ID:
Item Name: Extrusion "I" Beam Stop ***NS2***
Start Date: 6/9/2017 Start Qty: 80.00 ***80*** Cust Item ID:
Required Date: 7/6/2017 Req'd Qty: 80.00 ***80*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo ENSURE C OF C IS ATTACH	0.00 1.60							70x 8017-7-25
120 *120* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00							(20) 17-07-23 DAS 9 9-89
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : LG002	0.00 0.80							Ship to weyzy to sth 17-07-31

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Item ID: D3882-1-130

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Extrusion "I" Beam

Start Date: 6/9/2017 Start Qty: 80.00

80

Cust Item ID:

Required Date: 7/6/2017 Req'd Qty: 80.00

80

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

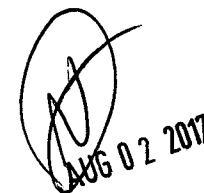
140

QC

Memo

8.00

Quality Control


AUG 02 2017

Thursday, June 08, 2017 1:22:25 PM

162690

D3882-1-130

Required Date: 7/6/2017

Required Qty: 80.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3882-1-130P		Purchased	No			100	Each	0.0000	1	80	70x		
D3882-1-130P									**70x	80 17-7-25			
EXTRUSION													



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36700

Purchase Order Date 6/14/2017

PO Print Date 6/14/2017

Page Number 2 of 3

Order From :
SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

VC-BON001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-427-6550

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: \$2,439.84

3	D2622-120CP	Extrusion	7/24/2017 Yes 7/24/2017	242.00 Each	\$20.09	\$4,862.00
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EXTRUDE AS PER DWG D2622-120 REV. C
B162484
DIE # DAA- 897123
LENGHT 120"

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE
MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS

Line Total: \$4,862.00

4	D3882-1-130P	EXTRUSION	7/24/2017 Yes 7/24/2017	63.00 Each	\$37.02	\$2,332.00
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EXTRUDE AS PER DWG D3882-1-130
B162690
DIE # DAA-6
LENGHT 130"

EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE
MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS

Line Total: \$2,332.00

PO Instructions: QUOTE NO. 06092017-012B

Note:

6/14/2017

*Recd 70x
8017-7-25*



**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
07/19/2017	5439615	128490	1
Cust PO	B/L No	Lot	Date
PO36700	032889	883849	07/24/17

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
004	DAA-6-1	130" MILL 6061 T6	D3882-1-130P
Gross Weight	1,221 LBS		
Net Qty	1,186 LBS	70 PCS	2 PKGS
Specification	Die Desc		
ASTM B221-13 DAS 9 9.89			

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
313.1 / 45.4	289.7 / 42.0	12.4	N/A	96

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.63	0.29	0.22	0.11	0.91	0.06	0.06	0.02	0.01	0.00

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A